

Work Order ID 85910

85910

Page 1

June-18-12 2:30:11 PM

Item ID: D3171-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Angle

Stop ***NS2***

Start Date: 18/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3171

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3171 Dwg Rev: A Prog Rev: B 2-
Deburr if necessary

304.063

B12-7-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-7-5

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S126215

counts
728

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Item Name: Angle

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Start Date: 18/06/2012 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***

QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3171Tumble								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

12/07/12

SB

B12-7-6

cutted
724

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 18/06/2012 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	Identify as per dwg & Stock Location: <u>ST 31</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

160

Packaging Memo 0.00

Packaging

24x

SP
12-7-9

170	QC21- Final Inspection - Work Order Release	0.00							
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170

QC Memo 0.00

Quality Control

OK 12/7/9

MF
12-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June-18-12 2:30:14 PM

Page 1

Work Order ID: 85910

85910

Parent Item: D3171-1

D3171-1

Parent Item Name: Angle

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A02.11.04New IssueKJ

IPP Rev:B 08-03-27 now on water jet DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	37.3846	0.0206	0.260211	5		

M304S16GA

304/316 Sheet .063

**

B12-7-5

Location

MAT020

121889

Loc Qty

37.384633

37.384633

Loc Code

122245

69

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

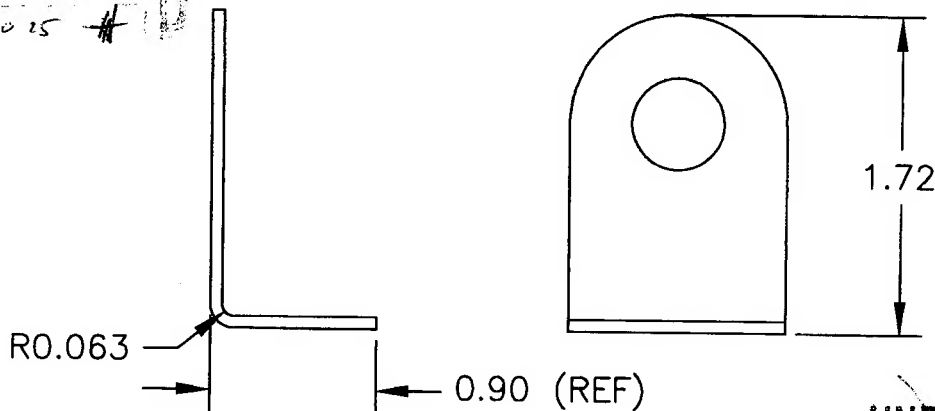
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3171	REV. A SHEET 1 OF 1
DATE 02.10.08		TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	

RELEASED
02.10.25 #



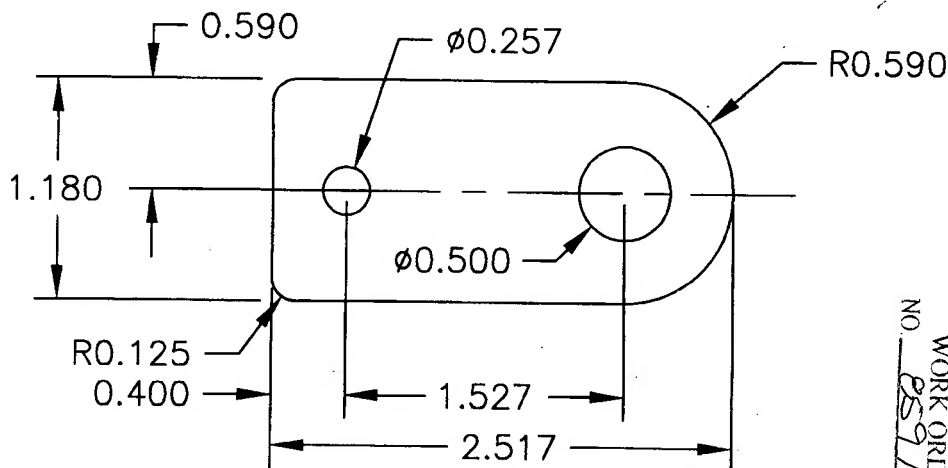
D3171-1 ANGLE

UNDER REVIEW

7.01.02 CB

adding -3

ok
CB
-3 not
being
used



D3171-1 ANGLE FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85910 M15

12/06/12

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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